

Date: Thursday, 3/2/2006 3:07:49 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HINGE BRACKET	
Job Number	: 26034		Part Number	: D28572	
Estimate Number	: 10347		Drawing Number	: D2857 REV A1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/2/2006 S.O. No. : N/A		Drawing Revision	: A1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 3/26/2006	
Previous Run	: 24626		Qty:	25	
Written By	: <u>See Comment Below</u>		Um:	24	
Checked & Approved By	: <u>JL</u> 06.03.02		Each		
Comment	: Est C 00.06.22 Removed P/O for powder coat EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"	
		Comment: Qty: 0.4594 f(s)/Unit Total: 11.0250 f(s) Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) (M6061T6B200001250) Batch M100451	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks 5.2"	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2857-1 D2857-2	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/04/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 3:07:50 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 26034

Part Number: D28572

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

SD 06.03.30

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

DC 06/04/01

25

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 06/04/01 25

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

PL 06/04/02 25

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PL 06/04/02 25

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: st 165

PL 06/04/02 25

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PL 06/04/02 25

Job Completion



PL 06/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26034
Description: Hinge Bracket		Part Number:	D2857-2
Inspection Dwg: D2857 Rev: A1		Page 1 of 1	

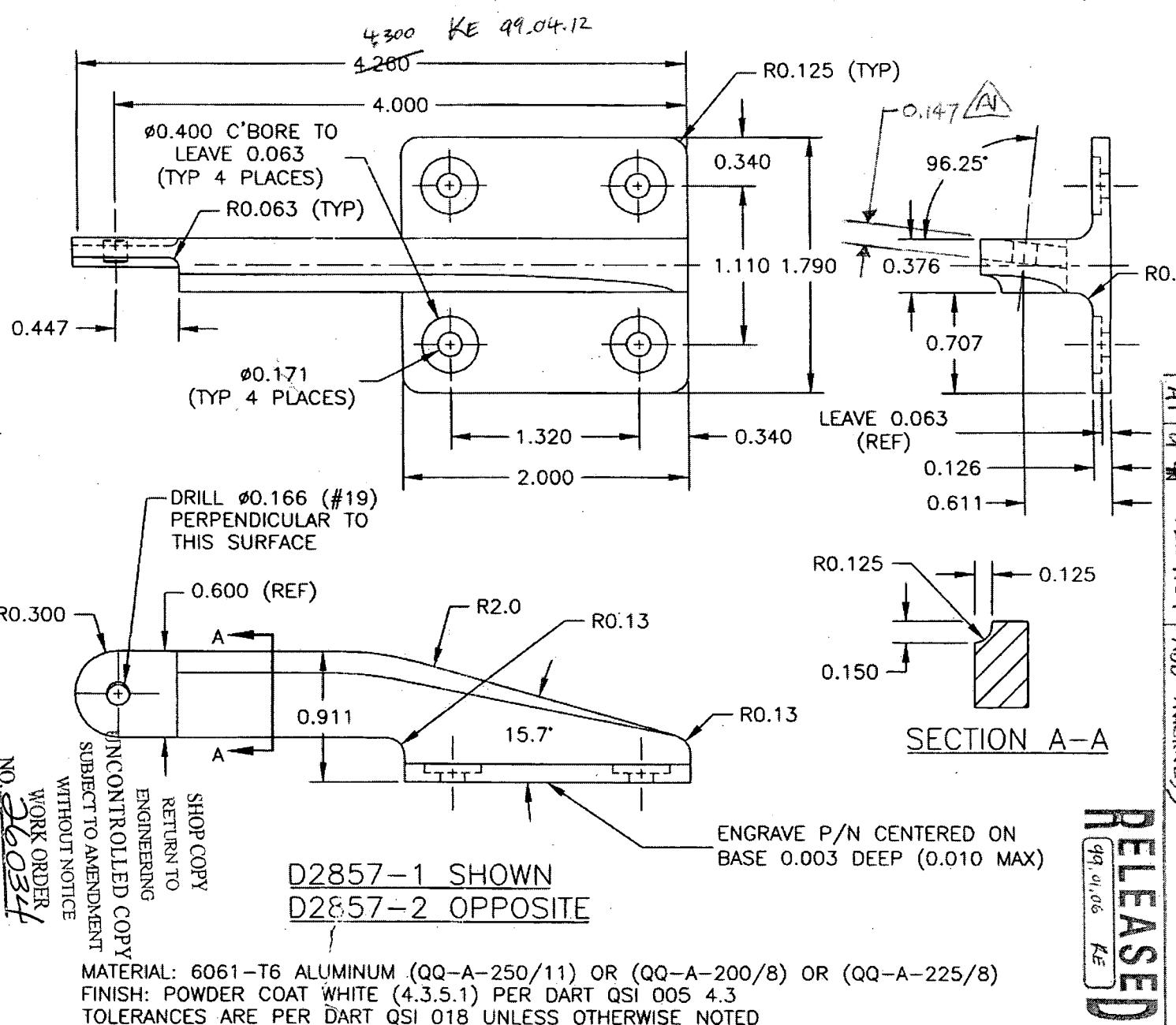
### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.301	✓			
0.340	+/-0.010	340	✓			
1.110	+/-0.005	1.110	✓			
1.790	+/-0.010	1.790	✓			
1.320	+/-0.005	1.320	✓			
2.000	+/-0.010	2.000	✓			
Ø0.171	+0.005/-0.000	174	✓			
0.147	+/-0.010	145	✓			
0.376	+/-0.010	375	✓			
0.126	+/-0.010	128	✓			
0.611	+/-0.010	612	✓			
0.063	+/-0.010	067	✓			
Ø0.166	+0.005/-0.000	168	✓			
0.911	+/-0.010	912	✓			
0.600	+/-0.010	609	✓			
0.125	+/-0.010	129	✓			
0.150	+/-0.010	150	✓			

Measured by:	J.L	Audited by:	S	Prototype Approval:	N/A
Date:	06.03.29	Date:	06/03/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	



DART

© COPY 45  
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE	REV. A	REVISION
KE	GP	D2857
98.12.14	98.12.14	NEW ISSUE
A1	GP	02.04.21
		AUD THICKNESS
		SECTION A-A
		RELEASED 99.01.06 KE